

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004232**Date Inspected:** 20-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Lin Yan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Due to thunderstorms the ZPMC transportation ferry did not run any boats and the QA Inspectors had no transportation to the work site until a ZPMC tugboat arrived to take the QA Inspectors to the ZPMC work site. After the ferry landed the QA Inspectors arrived in the Caltrans office at approximately 1915 hours.

Bay 1

The QA Inspector observed that macroetch samples taken from the closed rib tack weld test plates that had been welded yesterday are sitting on the floor in a pile adjacent to the abrasive cut off saw which appears to have been used to cut the specimens. The specimens have not been etched. No ZPMC personnel were observed to be etching or polishing these specimens.

Deck plate DP416-001 has closed ribs tack welded to the baseplate which is clamped to the east end of gantry 1. These tack welds do not appear to have been MT inspected by ZPMC QC personnel.

ZPMC welders are tack welding closed ribs to deck plate DP335-001.

Heavy Bay 1

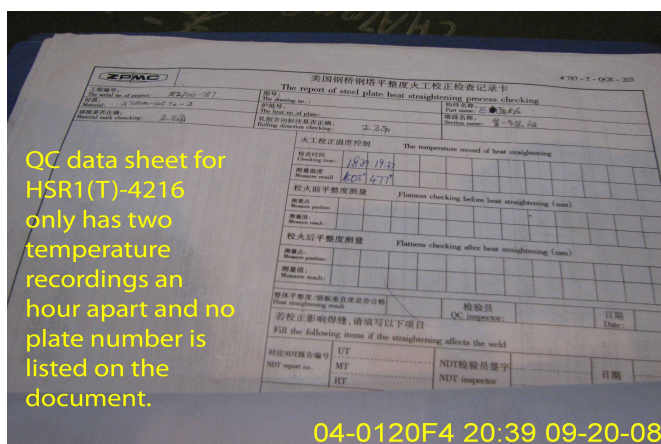
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Two welders are welding splice plate "C" weld SSD1-SA106 1A and 4A. The QA Inspector verified the base material appears to have been properly preheated to a temperature of 110°C.

The QA Inspector observed a ZPMC worker performing flame straightening of plate P1109. The QA Inspector asked ZPMC CWI Mr. Lin Yan if ZPMC has approval to perform this flame straightening. Mr. Lin Yan did not appear to have a copy of any flame straightening documents for this plate at the location of the work. Approximately 20 minutes later Mr. Lin Yan showed the QA Inspector a copy of HSR1(T)-3741 which addresses the flame straightening of this plate.

Two workers are flame straightening plate SSD1-SA159/SSD1SA15 in accordance with HSR1(T)4216. At 2037 hours the QA Inspector reviewed the QC documentation and observed the QC Inspector had documented only two temperature measurements for this flame straightening, one was at 1837 hours and the second was at 1947 hours. The data sheet that the QC Inspector was using also did not contain the plate number that was being flame straightened. The QA Inspector informed ZPMC CWI Mr. Ling Yang that the plate number should be recorded on all flame straightening data sheets and that it appears that the QC Inspector is only recording temperature measurements every hour. Mr. Yang said he will instruct the QC Inspector to write the plate number on the HSR data sheets and more frequent measurements will be taken in the future.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul
Reviewed By: Carreon,Albert

Quality Assurance Inspector
QA Reviewer